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Docket No.: D-6384

Inventors: DiMAIO ET AL.

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Page 1 of 2

Assistant Commissioner for Patents
Box Patent Application
Washington, D.C. 20231

UTILITY PATENT APPLICATION TRANSMITTAL
UNDER 37 CFR 1.53(b)

Sir:

Enclosed herewith for filing are:

1. The patent application of:

Inventor(s): ANTHONY J. DiMAIO;
JOHN R. BARANSKI
JOHN G. BLUDWORTH and
DANIEL J. GILLIS

Title: *"PROCESS FOR PRODUCING LIQUID POLYALPHAOLEFIN
POLYMER, METALLOCENE CATALYST THEREFOR, THE
RESULTING POLYMER AND LUBRICANT CONTAINING SAME"*

Total pages 48

2. Application
a. New Application
b. Continuation Divisional Continuation-in-part
of U. S. Application Serial No. _____, filed on _____.
3. Drawings (-) sheets of drawings
4. Oath or Declaration (Total pages - 3)
a. Newly executed (original)
b. Copy from prior application (37 CFR 1.63(d))
(for continuation/divisional application)
5. Incorporation By Reference
The entire disclosure of the prior application, from which a copy of the oath
or declaration is supplied under Box 4 above, is considered as being part of the
disclosure of the accompanying application and is hereby incorporated by reference
therein.
6. An assignment of the invention to UNIROYAL CHEMICAL COMPANY, INC. and cover
sheet.
7. Associate Power of Attorney
8. Information Disclosure Statement/PTO 1449
9. Preliminary Amendment
10. Return Receipt Postcard

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11. (X) Form PTO-1595 (Assignment Recordal Form)

12. The fee has been calculated as shown below:

	Claims Filed	Extra Claims	Rate	Fee
Basic Fee				\$690.00
Total Claims	37-20	-17-	X \$18	\$306.00
Independent Claims	2-3	-0-	X \$78	-0-
[] Multiple dependent claims presented			+ \$260	-0-
			Total Fee	\$996.00

13. (X) Charge Deposit Account No. 21-0525 in the amount of \$ 996.00

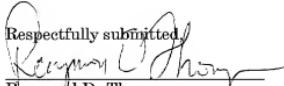
14. (X) The Commissioner is hereby authorized to charge payment of the following fees associated with this communication or credit any overpayment to Deposit Account No. 21-0525 any additional filing fees required under 37 CFR 1.16 and any patent application processing fees under 37 CFR 1.17.

15. (X) The Commissioner is hereby authorized to charge payment of the following fees during the pendency of this application or credit any overpayment to Deposit Account No. 21-0525; any patent application processing fees under 37 CFR 1.17 and any filing fees under 37 CFR 1.16 for presentation of extra claims.

Copies in duplicate are enclosed

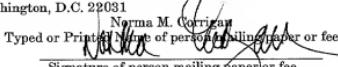
Date: August 11, 2000

Respectfully submitted,


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PROCESS FOR PRODUCING LIQUID POLYALPHAOLEFIN
POLYMER, METALLOCENE CATALYST THEREFOR,
THE RESULTING POLYMER AND LUBRICANT CONTAINING SAME

BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to a process for producing a liquid polyalphaolefin homopolymer, e.g., 1-decene, or copolymer, e.g., one derived from 1-decene, employing 5 hydrogen and a metallocene catalyst therefor, to the resulting polymer and to a lubricant composition in which the liquid polyalphaolefin functions as a viscosity modifier.

2. Description of the Prior Art

Catalytic oligomerization of olefins is a known technique for manufacturing hydrocarbon basestocks useful as lubricants. Efforts to improve upon the 10 performance of natural mineral oil based lubricants by the synthesis of oligomeric hydrocarbon fluids have been the subject of important research and development in the petroleum industry for several decades, leading to recent commercial production of a number of superior poly(alphaolefin) synthetic lubricants (hereinafter referred to as "PAO"). These materials are primarily based on the oligomerization of alphaolefins such 15 as C₂-C₂₀ olefins. Industrial research effort on synthetic lubricants has generally focused on fluids exhibiting useful viscosities over a wide range of temperature, i.e., improved viscosity index (VI), while also showing lubricity, thermal and oxidative stability and pour point equal to or better than mineral oil. These newer synthetic lubricants provide

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lower friction and hence increase mechanical efficiency across the full spectrum of mechanical loads and do so over a wider range of operating conditions than mineral oil lubricants.

Well known structural and physical property relationships for high polymers as contained in the various disciplines of polymer chemistry have pointed the way to alphaolefins as a fruitful field of investigation for the synthesis of oligomers with the structure thought to be needed to confer improved lubricant properties thereon. Due largely to studies on the polymerization of propene and vinyl monomers, the mechanism of the polymerization of alphaolefins and the effect of that mechanism on polymer structure is reasonably well understood, providing a strong resource for targeting on potentially useful oligomerization methods and oligomer structures. Building on that resource, oligomers of alphaolefins from 2 to 20 carbon atoms have been prepared with commercially useful synthetic lubricants from, e.g., 1-decene oligomerization, yielding a distinctly superior lubricant product via either cationic or Ziegler catalyzed polymerization.

A significant problem in the manufacture of synthetic lubricants is the production of lubricants in a preferred viscosity range in good yield without excessive catalyst deactivation. Frequently, it is difficult to directly produce lower viscosity range lubes without incurring lower yields due to the production of non-lubricant range materials. Methods to control molecular weight of lubricants in the oligomerization step are sought after in the art to overcome the problems in the manufacture of, particularly, lower viscosity lubricants.

SUMMARY OF THE INVENTION

It is an object of the present invention to provide a polymerization process, e.g., one carried out under solution or slurry conditions and in batch or continuously, for producing a liquid polyalphaolefin polymer employing hydrogen and as the catalyst composition an activated bridged metallocene in which the bridging group possesses at least two bulky groups.

It is a further object of the invention to provide such a process for the polymerization of olefins which eliminates the need for a hydrogenation step to provide saturated liquid, low molecular weight polyalphaolefin homopolymers, e.g., 1-decene, or copolymers, e.g., one derived from 1-decene.

Additional objects of the invention include providing a liquid polyolefin homo- or copolymer containing from 2 to about 12 carbon atoms possessing a combination of low molecular weight (M_w), low polydispersity index (M_w/M_n), controllable kinematic viscosity (Kv_{100}), low Iodine Number (I_2), and low glass transition temperature (T_g) with the resulting polyolefin being substantially amorphous, the process comprising contacting at least one monomer having from 2 to about 12 carbon atoms under polymerization conditions with hydrogen and a catalytically effective amount of a catalyst composition comprising the product obtained by combining (a) a metallocene procatalyst, preferably one containing a bridging group possessing at least two bulky groups, and (b) a cocatalyst, preferably an aluminoxane.

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The terms "metallocene" and "metallocene procatalyst" as used herein shall be understood to refer to compounds possessing a transition metal M, at least one non-cyclopentadienyl-derived ligand X and zero or one heteroatom-containing ligand Y, the ligand being coordinated to M and corresponding in number to the valence thereof.

Such compounds, cocatalysts useful for their activation to provide metallocene catalysts that may be employed for the polymerization of olefins to provide polyolefin homopolymers and copolymers and/or polymerization processes employing one or more of the metallocene catalysts are described in, among others, U.S. Patent Nos. 4,752,597; 4,892,851; 4,931,417; 4,931,517; 4,933,403; 5,001,205; 5,017,714; 5,026,798; 5,034,549; 5,036,034; 5,055,438; 5,064,802; 5,086,134; 5,087,677; 5,126,301; 5,126,303; 5,132,262; 5,132,380; 5,132,381; 5,145,819; 5,153,157; 5,155,080; 5,225,501; 5,227,478; 5,241,025; 5,243,002; 5,278,119; 5,278,265; 5,281,679; 5,296,434; 5,304,614; 5,308,817; 5,324,800; 5,328,969; 5,329,031; 5,330,948; 5,331,057; 5,349,032; 5,372,980; 5,374,753; 5,385,877; 5,391,629; 5,391,789; 5,399,636; 5,401,817; 5,406,013; 5,416,177; 5,416,178; 5,416,228; 5,427,991; 5,439,994; 5,441,920; 5,442,020; 5,449,651; 5,453,410; 5,455,365; 5,455,366; 5,459,117; 5,466,649; 5,470,811; 5,470,927; 5,477,895; 5,491,205; and, 5,491,207, the contents of which are incorporated by reference herein.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

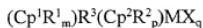
The liquid polyalphaolefin polymers of this invention are substantially saturated, i.e., one possessing a low iodine number which is discussed hereinbelow, and can be obtained by polymerizing at least one monomer, e.g., 1-decene, in the presence of

hydrogen and a catalyst composition formed by activating a metallocene procatalyst with a suitable cocatalyst.

The α -olefins suitable for use in the preparation of the saturated, liquid polyalphaolefin polymers described herein contain from 2 to about 20 carbon atoms and preferably from about 6 to about 12 carbon atoms. Suitable α -olefins include ethylene, propylene, 2-methylpropene, 1-butene, 3-methyl-1-butene, 1-pentene, 4-methyl-1-pentene, 1-hexene, 1-heptene, 1-octene, 1-nonene, 1-decene, 1-undecene, 1-dodecene, 1-tridecene, 1-tetradecene, 1-pentadecene, 1-hexadecene, 1-heptadecene, 1-octadecene, 1-nonadecene, 1-eicosene and the like and vinyl aromatic monomers such as styrene, α -methyl styrene and the like. Preferred α -olefins for use herein are 1-octene, 1-decene and 1-dodecene with 1-decene being most preferred.

The preferred liquid polyalphaolefin homopolymer will contain up to about 100 weight percent 1-decene while the preferred liquid polyalphaolefin copolymer can contain up to about 95, preferably from about 20 to about 90, and more preferably from about 30 to about 85, weight percent 1-decene, the balance being other α -olefin(s).

The catalyst composition for use herein is formed by activating a metallocene procatalyst with a suitable catalyst. The metallocene procatalyst is preferably one or a mixture of metallocene compounds of the following general formula:

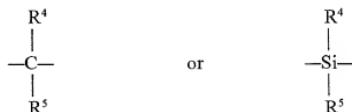


wherein Cp^1 of ligand $(Cp^1R^1_m)$ and Cp^2 of ligand $(Cp^2R^2_p)$ are the same or different cyclopentadienyl rings, R^1 and R^2 each is, independently, hydrogen or a hydrocarbyl, halocarbyl, heterocarbyl, hydrocarbyl-substituted organometalloid or halocarbyl-

substituted organometalloid group containing up to about 20 carbon atoms, m is 0 to 5, p is 0 to 5 and two R¹ and/or R² substituents on adjacent carbon atoms of the cyclopentadienyl ring associated therewith can be joined together to form a ring fused to the cyclopentadienyl ring, the fused ring containing from 4 to about 20 carbon atoms, R³ is a bridging group bridging Cp¹ and Cp², M is a transition metal having a valence of 3 to 6, each X is a non-cyclopentadienyl ligand and is, independently, halogen or a hydrocarbyl, oxyhydrocarbyl, halocarbyl, hydrocarbyl-substituted organometalloid, oxyhydrocarbyl-substituted organometalloid or halocarbyl-substituted organometalloid group containing up to about 20 carbon atoms, and q is equal to the valence of M minus

known in the art and do not constitute a part of the present invention.

When employing the foregoing metallocene procatalyst and the cocatalyst is entirely an aluminoxane, ligand ($Cp^1R^1_m$) must be different from ligand ($Cp^2R^2_p$), and bridging group R^3 must contain at least two bulky groups. Of these bridged metallocenes, it is preferred that bridging group R^3 possess the structure



in which bulky groups R⁴ and R⁵ each, independently, is, or contains, a cyclohydrocarbyl group containing up to about 20, and preferably from 6 to about 12, carbon atoms and

from 0 to 3 heteroatoms such as oxygen, sulfur, tertiary nitrogen, boron or phosphorus and, in particular, is a cycloalkyl, heterocycloalkyl, cycloalkenyl, heterocycloalkenyl, aryl, heteroaryl, alkaryl, alkylheteroaryl, aralkyl, heteroaralkyl, and so forth, M is titanium, zirconium or hafnium, q is 2 and each X is halogen.

5 Of this preferred group of bridged metallocenes, those in which ligand ($Cp^1R_m^1$) is substituted or unsubstituted cyclopentadienyl, ligand ($Cp^2R_p^2$) is indenyl or fluorenyl, M is zirconium, R⁴ and R⁵ each is substituted or unsubstituted phenyl and each X ligand is chlorine are still more preferred.

Still other preferred bridged metallocenes (I) that can be used in the polymerization process of this invention include:

10 diphenylmethylene(indenyl)(fluorenyl)zirconium dichloride,
diphenylmethylene(cyclopentadienyl)(4,5,6,7-tetrahydro-indenyl)zirconium dichloride,
diphenylmethylene(cyclopentadienyl)(2-methylindenyl) zirconium dichloride,
diphenylmethylene(2,4-dimethylcyclo-pentadienyl)(3',5'-
15 dimethylcyclopentadienyl)zirconium dichloride,
diphenylmethylene(2-methyl-4-tert-butylcyclo-pentadienyl) (3'-tert-butyl-5'-
methylcyclopentadienyl)zirconium dichloride,
dixylylmethylene(2,3,5-trimethylcyclopentadienyl)
(2',4',5'-trimethylcyclopentadienyl)zirconium dichloride, dixylylmethylene(2,4-
20 dimethylcyclopentadienyl)(3',5'-dimethylcyclopentadienyl)zirconium dichloride,
dixylylmethylene(2-methyl-4-tert-butylcyclopentadienyl)
(3'-tert-butyl-5-methylcyclopentadienyl)zirconium dichloride,

dixylylmethylene(cyclopentadienyl)(fluorenyl)zirconium dichloride,
di-o-tolylmethylene(cyclopentadienyl)(3,4-dimethyl-cyclopentadienyl)zirconium
dichloride,
di-o-tolylmethylene(cyclopentadienyl)(3,4-dimethyl-cyclopentadienyl)zirconium
5 dichloride,
di-o-tolylmethylene(cyclopentadienyl)(3,4-dimethylcyclopentadienyl)zirconium
dichloride,
di-o-tolylmethylene(cyclopentadienyl)(indenyl)zirconium dichloride,
10 dibenzylmethylene(cyclopentadienyl)(tetramethylcyclopentadienyl)zirconium dichloride,
dibenzylmethylene(cyclopentadienyl)(indenyl)zirconium dichloride,
dibenzylmethylene(cyclopentadienyl)(fluorenyl)zirconium dichloride,
dicyclohexylmethylene(cyclopentadienyl)(indenyl)zirconium dichloride,
15 dicyclohexyl(cyclopentadienyl)(fluorenyl)zirconium dichloride,
dicyclohexylmethylenec(2-methylcyclopentadienyl)(fluorenyl) zirconium dichloride,
diphenylsilyl(2,4-dimethylcyclopentadienyl)(3',5'-dimethyl-cyclopentadienyl)zirconium
dichloride,
20 diphenylsilyl(2,4-dimethylcyclopentadienyl)(3',5'-dimethyl-cyclopentadienyl)zirconium
dichloride,
diphenylsilyl(2,3,5-trimethylcyclopentadienyl)(2,4,5-
trimethylcyclopentadienyl)zirconium dichloride,
tetraphenyldisilyl(cyclopentadienyl)(indenyl)zirconium dichloride,
tetraphenyldisilyl(3-methylcyclopentadienyl)(indenyl) zirconium dichloride,

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tetraphenyldisilyl(cyclopentadienyl)(fluorenyl)zirconium dichloride,
di-o-tolylsilyl(cyclopentadienyl)(trimethylcyclopentadienyl) zirconium dichloride,
di-o-tolylsilyl(cyclopentadienyl)(tetramethylcyclopentadienyl)zirconium dichloride,
di-o-tolylsilyl(cyclopentadienyl)(3,4-diethylcyclopentadienyl)zirconium dichloride,
5 di-o-tolylsilyl(cyclopentadienyl)(triethylcyclopentadienyl) zirconium dichloride,
dibenzylsilyl(cyclopentadienyl)(fluorenyl)zirconium dichloride,
dibenzylsilyl(cyclopentadienyl)(2,7-di-t-butyl-fluorenyl)zirconium dichloride, and
dicyclohexylsilyl(cyclopentadienyl)(fluorenyl)zirconium dichloride.

The cocatalyst, or activator, employed with the preferred bridged
10 metallocene procatalysts of formula (I) can be any of the aluminoxanes known to activate
metallocene procatalysts. For further details of the aluminoxane cocatalysts including
such alkylaluminoxanes as MAO see, e.g., U.S. Patent No. 5,229,478. In general, the
bridged metallocene procatalyst can be present in the reactor in an amount, expressed in
terms of its transition metal content, of from about 0.0001 to about 0.02, preferably from
15 about 0.0002 to about 0.015 and more preferably from about 0.00025 to about 0.01,
millimoles/liter. Corresponding to these amounts of transition metal, the aluminoxane
cocatalyst can be utilized in an amount of from about 0.01 to about 100, preferably from
about 0.02 to about 75 and more preferably from about 0.025 to about 50,
millimoles/liter. It will, of course, be recognized that optimum levels of bridged
20 metallocene procatalyst and aluminoxane cocatalyst will to some extent depend upon the
specific procatalyst and cocatalyst selected as well as other polymerization process
variables.

When employing an aluminoxane cocatalyst, it can be advantageous to include a trialkylaluminum such as trimethylaluminum, triethylaluminum, tri(n-propyl)aluminum, triisopropylaluminum, tri(n-butyl)aluminum, triisobutyl-aluminum, and the like, to reduce the amount of aluminoxane required for suitable activation of the metallocene procatalyst. In general, the optional trialkylaluminum can be utilized in a molar ratio to metallocene procatalyst of from about 1 to about 1000 and preferably from about 2 to about 500.

It is also contemplated that a neutral or anionic metal- and/or metalloid-containing component can optionally be employed with the aluminoxane cocatalyst in activating the metallocene procatalyst.

Useful neutral metal- and/or metalloid-containing components for use herein include boranes such as perfluoroarylborane compounds, e.g., tris(pentafluorophenyl)borane, tris(methoxyphenyl)borane, tris(trifluoromethylphenyl)borane, tris(3,5-di[trifluoro-methyl]phenyl)borane, tris(tetrafluoroxylyl)borane, tris(tetrafluoro-o-tolyl)borane, etc., and the like. Of the foregoing boranes, tris(pentafluorophenyl)borane and tris(3,5-di[trifluoromethyl]phenyl)borane are preferred. Other useful second components include aluminum homologues of the foregoing compounds.

Suitable anionic metal- and/or metalloid-containing components for use herein include borates such as perfluoroaryl borates, e.g., lithium tetrakis(pentafluorophenyl)borate, lithium tetrakis(trifluoromethylphenyl)borate, lithium tetrakis(3,5-di[tri-fluoromethyl]phenyl)borate, sodium tetrakis(pentafluoro-phenyl)borate,

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potassium tetrakis(pentafluorophenyl)borate, magnesium tetrakis(pentafluorophenyl)borate, titanium tetrakis(pentafluorophenyl)borate, tin tetrakis(pentafluorophenyl)borate, dimethylanilinium tetrakis(pentafluorophenyl)borate, etc., and the like. Of the foregoing borates, dimethylanilinium 5 tetrakis(pentafluorophenyl)borate and alkali metal borates such as lithium tetrakis(pentafluorophenyl)borate and lithium tetrakis(3,5-di[trifluoromethyl]phenyl)borate are preferred. Other useful components include aluminate homologues of the foregoing compounds.

10 In general, the optional neutral or anionic metal- and/or metalloid-containing components can be utilized in a molar ratio to metallocene procatalyst of from about 0.1 to about 10 and preferably from about 0.5 to about 3.

15 Activation of the metallocene can be achieved by combining the aforementioned metallocene procatalysts with the aluminoxane cocatalyst either simultaneously or in any sequence and with any interval of time therebetween and either within the presence of, or in the absence of, the olefin monomer(s) and hydrogen.

20 It is particularly advantageous to prepare the activated metallocene catalyst compositions in advance and thereafter introduce it into the polymerization reactor with the olefin monomer(s) in the presence of hydrogen. The reaction of the metallocene procatalyst with the aluminoxane cocatalyst is advantageously conducted at a temperature ranging from about 0 to about 50°C for a time period of from about 1 minute to about 72 hours.

Polymerization or copolymerization of the aforementioned monomers

using hydrogen and the catalyst herein can be carried out in any known manner, e.g., in the liquid phase, i.e., in a solution or slurry process, or in a suspension process, either continuously or in batch. These processes are generally carried out at temperatures in the range of from about 0°C to about 200°C and preferably from about 50°C to about 150°C, and pressures from about 10 to about 3000 psig. As one skilled in the art would readily appreciate, control of the polymerization temperature has a direct bearing on the quality of the polymerization, e.g., activity, as well as the final product properties, e.g., Iodine Number. However, as these temperatures approach 150°C or greater, the exothermic temperature, i.e., the maximum temperature reached during the polymerization, should be substantially close to the initial polymerization temperature, e.g., at temperatures above about 150°C the exothermic temperature should be no more than about 20°C greater than the initial polymerization temperature.

Due to the nature of the final liquid polyolefin, the polymerization can be carried out in liquid monomer and in the absence of solvent or, if desired, in the presence of solvent. Dilution solvents that can be employed include straight and branched chain hydrocarbons such as the butanes, the pentanes, the hexanes, the heptanes, the octanes, and the like, cyclic and alicyclic hydrocarbons such as cyclopentane, cyclohexane, cycloheptane, methyl-cyclopentane, methylcyclohexane, methylcycloheptane and the like, and alkyl-substituted aromatic compounds such as toluene, xylene, and the like and mixtures thereof.

A typical batch solution polymerization process can be carried out by first introducing the liquid monomer, e.g., 1-decene, either alone or in combination with an optional hydrocarbon solvent, e.g., hexane, xylenes, etc., into a stirred tank reactor. If copolymerization with an additional liquid monomer is desired, e.g., 1-octene, it can be
5 added either sequentially or simultaneously with the other monomer. A minor amount of an inert impurity scavenger, e.g., the aforementioned trialkylaluminum compounds, can also be added at this time. The reactor is then brought up to the desired temperature, e.g., from about 0 to about 200°C, preferably from about 20 to about 175°C, and a measured amount of hydrogen is then introduced into the stirred tank reactor. If copolymerization
10 is desired with a gaseous monomer, a monomer feed comprising, for example, 1-decene, is then sparged into the liquid phase, either in combination with, or separate from the hydrogen feed. By carrying out the polymerization reaction in the presence of hydrogen and employing the catalyst herein, a hydrogenation step is eliminated and the liquid polyalphaolefins of this invention are substantially saturated and, therefore, will possess a
15 low iodine value, e.g., an Iodine Number of from about 0.0 to about 10, preferably from about 0.1 to about 5, and most preferably from about 0.2 to about 3.

Once the desired conditions are established, a hydrocarbon solution of the catalyst in the required amounts are then added to the liquid phase in the reactor. The rate of polymerization is controlled by the concentration of the catalyst and monomer(s)
20 present or added during polymerization. The reactor temperature is controlled by means of cooling coils, etc., and the initial total pressure in the reactor is maintained by a

constant flow of hydrogen, inert gas, gaseous monomer(s) or a combination thereof.

After polymerization is complete, the reactor is depressurized and the catalyst is deactivated by conventional means.

Depending on the amount of monomer conversion and viscosity of the

5 reactor contents, a hydrocarbon solvent can be added to aid in removal the product liquid polyolefin. Spent catalyst components can be isolated from the reaction product via mixing with, e.g., alcohol, water or a mixture of both, then by phase separation of the hydrocarbyl component from the aqueous component. The liquid polyolefin can then be recovered from the hydrocarbyl component by conventional methods, e.g., evaporation, distillation, etc., and then further processed as desired.

10 The liquid polyalphaolefin homo- or copolymers containing from about 2 to about 12 carbon atoms that can be obtained by the polymerization process herein are substantially amorphous, i.e., wherein a crystalline phase is substantially absent from the resulting polyolefin as defined by an exothermic peak observation in a differential scanning calorimetry (DSC) experiment. In addition to being substantially amorphous, liquid polyalphaolefin homo- or copolymers containing from about 2 to about 12 carbon atoms that can be obtained by the polymerization process herein possess a unique combination of low molecular weight (M_w), low polydispersity index (M_w/M_n), controllable kinematic viscosity (Kv_{100}), high viscosity index (VI), low Iodine Number (I₂), i.e., a substantially saturated polyolefin, and low glass transition temperature (T_g) that distinguish them from known liquid polyolefin. The novel liquid polyalphaolefin homo- or copolymers having from 2 to about 12 carbons of this invention are

substantially amorphous and possess a M_w of from about 500 to about 80,000, preferably from about 750 to about 60,000 and more preferably from about 1,000 to about 40,000, a M_w/M_n of from about 1.0 to about 10, preferably from about 1.5 to about 5 and more preferably from about 1.75 to about 4, a Kv_{100} of from about 10 to about 10,000,
5 preferably from about 20 to about 7,500 and more preferably from about 25 to about 5,000, an Iodine Number of from about 0.0 to about 10, preferably from about 0.1 to about 5, and most preferably from about 0.2 to about 3 and a T_g of below about -20°C, preferably below about -30°C and more preferably below about -40°C.

These advantageous properties can be exploited in a variety of products such as, for example, products which require a viscous oil or an inert material with fluid properties such as dispersants, heat transfer fluids, cosmetics or other such consumer products, and the like. Additionally, the products of this invention can be used in grafting applications to produce functionalized low molecular weight polymers. The polyalphaolefin polymers of this invention are particularly useful as a viscosity modifier for lubricating oils wherein the polymer is employed in a viscosity-modifying amount.
10 Concentrations of from about 1 to about 99 weight percent based on the total weight of the lubricating oil composition can be used. Preferably, the concentration is from about 5 to about 85 weight percent.
15

In general, mineral oils, both paraffinic, naphthenic and mixtures thereof, including those oils defined as American Petroleum Institute Groups I, II, and III can be employed as the lubricant vehicle, and can be any suitable lubricating viscosity range, as for example, from about 2 cSt at 100°C to about 1,000 cSt at 100°C and preferably from

about 2 to about 100 cSt at 100°C. These oils can have viscosity indexes preferably ranging to about 180. The average molecular weights of these oils can range from about 250 to about 800. Where synthetic oils are employed, they can include, but are not limited to, polyisobutylene, polybutenes, hydrogenated polydecenes, polypropylene glycol, polyethylene glycol, trimethylpropane esters, neopentyl and pentaerythritol esters, di(2-ethylhexyl) sebacate, di(2-ethylhexyl) adipate, dibutyl phthalate, fluorocarbons, silicate esters, silanes, esters of phosphorus-containing acids, liquid ureas, ferrocene derivatives, hydrogenated synthetic oils, chain-type polyphenyls, siloxanes and silicones (polysiloxanes), alkylsubstituted diphenyl ethers typified by a butyl-substituted bis(p-phenoxy phenyl) ether, and phenoxy phenylethers.

The lubricating oil compositions herein can also contain one or more other materials. For example, detergents, corrosion inhibitors, oxidative inhibitors, dispersants, pour point dispersants, anti-foaming agents, anti-wear agents, other viscosity modifiers, friction modifiers and the like at the usual levels in accordance with well known practice.

Other materials which can be employed herein include extreme pressure agents, low temperature properties modifiers and the like can be used as exemplified respectively by metallic phenates or sulfonates, polymeric succinimides, non-metallic or metallic phosphorodithioates and the like, at the usual levels in accordance with well known practice. These materials do not detract from the value of the compositions of this invention, rather the materials serve to impart their customary properties to the particular compositions in which they are incorporated.

EXAMPLES

The examples that follow include those that are illustrative of the invention (Examples 1-31) and those that are outside the scope of this invention (Comparative Examples A-K). The procatalysts, cocatalyst, solvents and monomers employed in these examples are as follows:

1. diphenylmethyldene(cyclopentadienyl)-(9-fluorenyl)zirconium dichloride [$\text{[Ph}_2\text{C}(\text{Cp-9-Flu})\text{ZrCl}_2]$]
2. diphenylmethyldene(3-n-butyl-cyclopentadienyl)-(9-fluorenyl)zirconium dichloride [$\text{[Ph}_2\text{C}(\text{nBuCp-9-Flu})\text{ZrCl}_2]$]
3. diphenylsilyl(cyclopentadienyl)-(9-fluorenyl)zirconium dichloride [$\text{[Ph}_2\text{Si}(\text{Cp-9-Flu})\text{ZrCl}_2]$]
4. isopropylidene(cyclopentadienyl)-(9-fluorenyl)zirconium dichloride [$\text{[Me}_2\text{C}(\text{Cp-9-Flu})\text{ZrCl}_2]$]
5. dimethylsilylbis(9-fluorenyl)zirconium dichloride [$\text{[Me}_2\text{Si}(\text{Flu})_2\text{ZrCl}_2]$]
6. *racemic*-ethylenebis(1-indenyl)zirconium dichloride [$\text{[rac-Et(Ind)}_2\text{ZrCl}_2]$]
7. dimethylsilylbis(cyclopentadienyl)zirconium dichloride [$\text{[Me}_2\text{Si}(\text{Cp})_2\text{ZrCl}_2]$]
8. *racemic*-dimethylsilylbis(2-methyl-1-indenyl)zirconium dichloride [$\text{[rac-Me}_2\text{Si}(2-\text{MeInd})_2\text{ZrCl}_2]$]
9. *meso*-dimethylsilylbis(2-methyl-1-indenyl)zirconium dichloride [$\text{[meso-Me}_2\text{Si}(2-\text{MeInd})_2\text{ZrCl}_2]$]
10. dimethylsilyl(tetramethylcyclopentadienyl)(*tert*-butylamido)titanium dichloride [$\text{[Me}_2\text{Si}(\text{C}_5\text{Me}_4)(\text{ButN})\text{TiCl}_2]$]

11. bis(cyclopentadienyl)zirconium dichloride [Cp_2ZrCl_2 ,]
12. bis(n-butyl-cyclopentadienyl)zirconium dichloride, [$(nBuCp)_2ZrCl_2$,]
13. Methyl aluminoxane [MAO], 10 weight % Al in toluene
14. Triisobutylaluminum [$Al(Bu')_3$], 25 weight % Al in hexanes

5

Hexane solvent, olefin monomers 1-hexene, 1-octene, 1-decene, 1-dodecene and 1-hexadecene were purified over 3 Å molecular sieves and activated silica/alumina. Anhydrous grade toluene solvent was used as received from Aldrich Chemical Co. (Milwaukee, Wisconsin) and stored over dry, deoxygenated nitrogen or argon.

10 Unless indicated otherwise, all polymerizations were performed in a jacketed 3 liter Büchi autoclave reactor equipped with a magnetically coupled agitator, a thermocouple, and various inlets. The autoclave was flushed with nitrogen and anhydrous hexane prior to use, then filled with monomer(s) and optionally with an inert diluent. TIBAI was used optionally as an impurity scavenger, then the reactor was brought up to the desired pressure and temperature prior to addition of the catalyst components. Polymerization was started upon addition of catalyst components. If desired, reactor pressure was maintained by addition of Argon, Nitrogen and/or Hydrogen. The polymerization was terminated by depressurization of the autoclave, then transfer of the reactor contents into an agitated vessel containing a mixture of isopropanol and water acidified with 1% HCl. Periodically hexane was used to help facilitate removal of higher viscosity products from the reactor and into the wash vessel.

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The following procedures were used to determine the properties of the liquid polyolefins.

Kinematic Viscosity (K_v) and Viscosity Index (VI)

The kinematic viscosity (K_v) of the liquid polyolefins, K_v, was measured using a modified Ostwald viscometer according to ASTM standard D445 and reported at temperatures of 100 °C (K_v at 100 °C) or 40 °C (K_v at 40 °C). The viscosity index (VI) was measured according to ASTM standard D2270 using the measured kinematic viscosities for each polyolefin.

10 Weight Average Molecular Weight (M_w),
 Number Average Molecular Weight (M_n) and (M_w/M_n)

15 The molecular weights of the liquid polyolefins, M_w and M_n, were measured in tetrahydrofuran at 35 °C on a Waters GPC II gel permeation chromatograph equipped with a Waters RA401 refractive index detector and 5 Waters Styragel HT columns (HT6, HT5, HT4, HT3, and HT2). The flow rate was 1 ml./min., and the concentration was 0.25 %. Molecular weights were calculated from elution times calibrated against polystyrene standards from American Polymer Standards Corp. (ranging for 162 molecular weight to 600,000 molecular weight) using a quadratic fit.

20 Glass Transition Temperature (T_g) and Crystalline Transition Temperature (T_c)

The glass transition temperatures and crystalline transition temperatures of liquid polyolefins (T_g and T_c, respectively) were measured by differential scanning calorimetry upon 20-25 mg of polymer without molding. T_g is reported as the midpoint

of the glass transition, while T_g (if observed) is reported as the peak maximum of the exothermic peak on the heating curve of the sample, recorded on a Perkin Elmer DSC 7 differential scanning calorimeter (from -100°C to 180°C at a heating rate of 20°C/minute). Calibration was performed with both indium and octane standards.

5

Branching Ratio and Relative Unsaturation

The branch content of the liquid polyolefins were determined by infrared spectroscopy of thin polymer films on a Perkin-Elmer infrared spectrophotometer model Paragon 1000 PC, by comparison of the relative intensities of methyl to methylene groups in the polymer. This method closely parallels measurements from ASTM standard D3900, which determines the relative ethylene to propylene ratio in EP copolymers. Relative unsaturation in the polymer was qualitatively determined via analysis of the region from 800-1100 cm^{-1} and 1600-1700 cm^{-1} of the same polymer film.

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Unsaturation Determination by Iodine Number

The amount of unsaturation in the liquid polyolefins was determined by measurement of the Iodine Number (I_2 No.) which is defined as the number of grams of iodine that add to 100 grams of sample. Only halogen that combines with a sample by way of addition to double bonds is a true measurement of unsaturation. Substitution reactions and, to a lesser extent, splitting-out reactions contribute to some error in the determination. In this method, the slow rate of addition of iodine to double bonds is catalyzed by Mercuric Acetate allowing the reaction to be completed in about one hour

where the effects of the slower substitution and splitting-out reactions are minimized. The method was adapted from Gallo et al., "Unsaturation in Isoprene-Isobutylene Copolymers", Industrial and Engineering Chemistry, Vol. 40, (1948) pp. 1277-1280. An Iodine Number of less than about 5 is considered substantially saturated.

5

Polymer Analysis by NMR Spectroscopy

Polymer NMR analysis was provided by Process NMR Associates, LLC (Danbury, CT). Structural assignments performed included detection of unsaturation in polymer, carbon chemical shift assignments, analyses of monomer addition mechanisms and pentad, triad, and dyad sequence determinations. C₃ chemical shift assignments and integration were used to determine polymer sequence information. The C₃ resonance in these samples was structurally similar to the methyl resonance in polypropylene used for sequence determination in John C. Randall, "Polymer Sequence Determination" Academic Press, New York (1977) Chapter 1. The effect of substituting an alkyl chain at C₃ shifts the resonance position from 21 ppm to 34 ppm as well as reduces the overall chemical shift dispersion by approximately 28 percent. However, all pentad sequences were resolved in these polymer samples as was observed in polypropylene. Pentad functionalities were integrated and, triad, and dyad functionalities were calculated from the pentad functionalities.

20

The specific polymerization conditions and physical properties of the resulting polymers for each of the examples are summarized below in Tables 1-10, infra.

EXAMPLE 1

The dried 3 liter Büchi reactor was filled under argon with 750 ml of dry 1-decene monomer. To this, 1.15 ml of a 25% by wt. solution of triisobutylaluminum in hexane was added to scavenge moisture and impurities, and the reactor temperature was brought up to 70°C. Once the temperature reached 70°C, 1 mole of hydrogen gas was added to the reactor via pressure drop from a vessel of known volume. Then, a solution of 0.007 g of $\text{Ph}_2\text{C}(\text{Cp-9-Flu})\text{ZrCl}_2$ was dissolved in 8.8 ml of a 10 wt. % solution of MAO in toluene, which had been prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig argon pressure. The reactor was maintained at a temperature of 70°C and 200 psig for a period of 30 minutes.

When complete, the reactor was depressurized and 400 ml hexane was added to the polymerized decene solution to aid in transfer. The reactor contents were then pressure transferred to a vessel equipped with an agitator containing 100 ml of acidified isopropanol, and agitated for 2 minutes. A white flocculent material presumed to be an aluminum alkoxide precipitated and settled in the aqueous phase. One liter of deionized water was then added to the washed mixture, stirred, allowed to settle, and then the organic layer was removed from the aluminum residue-laden aqueous layer.

The polymer was obtained from the remaining organic solution by evaporation under reduced pressure in a rotary evaporator. 460 Grams of polyolefin material was obtained with a Mn of 9,000 and a polydispersity M_w/M_n of 2.00. DSC analysis gave a T_g of -72.6°C, with no indication of crystallinity. Kinematic viscosity

measurements at 100°C gave a viscosity of 635 cSt, and a viscosity index of 282.

Unsaturation as measured by Iodine Number was 0.9.

'H and ¹³C NMR analysis performed on this material indicated that there was no detectable unsaturation in the polymer. Polymer distribution analysis of the 5 polymer demonstrated that the product was primarily syndiotactic in structure; the triad %rr result was 72.95%, and the pentad %rrrr was 44.39%. NMR results are summarized in the table of Example 6.

EXAMPLE 2

The procedure of Example 1 was repeated with the same materials and amounts but using a higher temperature to note the dependence of polymer viscosity on reaction temperature. The reaction was set at an initial temperature of 95°C, then the reactor temperature was increased to 160°C before bringing it back under control at its original setpoint. After polymerization and workup, 450 grams of polymeric material was obtained with a M_n of 3,780 and a polydispersity M_w/M_n of 2.14. DSC analysis gave a glass transition temperature T_g of -76.6°C, with no indication of crystallinity. Kinematic viscosity measurements at 100°C gave a viscosity of 144 cSt, and a viscosity index of 217. Unsaturation as measured by Iodine number was 3.75. ¹H and ¹³C NMR analysis performed on this material indicated that there was no detectable unsaturation in the 15 polymer. Polymer distribution analysis of the polymer demonstrated that the product was primarily syndiotactic in structure; the triad %rr result was 56.87%, and the pentad %rrrr was 22.31%. NMR results are summarized in the table of Example 6.

EXAMPLE 3

The procedure of Example 1 was repeated using the same materials at 150°C temperature and under reactor control (i.e., the reactor did not exhibit a significant exotherm) to prepare material comparable to a commercially available poly(1-decene) at 5 100 cSt viscosity. After polymerization and workup, 133 grams of polymeric material was obtained. Kinematic viscosity measurements at 100°C gave a viscosity of 107 cSt, and a viscosity index of 210. Unsaturation as measured by Iodine number was 5.6.

A commercial sample of high viscosity poly(1-decene) known as Synton® PAO-100 available from Crompton Corporation (Middlebury, CT) was obtained and 10 compared against the material synthesized. It's Kv at 100°C was 100.3 cSt, and its VI was calculated at 171. Unsaturation as measured by Iodine number was 5.2. Thus, at comparable viscosities, the material of Example 3 exhibits an increase in viscosity index of 39 points, indicative of its improved temperature-viscosity behavior over the prior art.

EXAMPLES 4-12 AND COMPARATIVE EXAMPLE A

15 Examples 4-12 and Comparative Example A illustrate the effect of temperature on the polymerization of 1-decene using Ph₂C(Cp-9-Flu)ZrCl₂ and MAO under conditions similar to those of Examples 1-3 as shown below in Table 1. In all of the examples the molar ratio of MAO to procatalyst was maintained at 1000:1, although the catalyst charge may have differed.

TABLE 1

Example/ Comp. Ex	catalyst (g)	Temp. (°C)	Exotherm (°C)	Activity (Kg/geom)	% Decene Conversion	Kv (at 100°C)	Kv (at 40°C)	VI	I ₂ No.	
5	1	0.007	70	70	65.74	82.8	635	7,275	282	0.9
	2	0.007	95	160	64.25	81.0	144	1,371	217	3.8
	3	0.003	150	157	44.18	24.0	107	958	210	5.6
	4	0.014	40	43	26.05	65.6	2,463	34,232	344	0.4
	5	0.028	40	112	16.84	84.8	698	8,120	286	1.8
	6	0.014	70	115	33.42	84.2	282	2,884	246	2.6
10	7	0.014	70	150	32.49	81.8	175	1,657	228	5.2
	8	0.007	95	98	38.74	73.0	521	5,907	271	0.8
	9	0.007	95	122	66.00	83.0	316	3,303	250	2.2
	10	0.002	120	124	124.10	45.0	280	2,872	245	1.8
	11	0.007	150	169	40.61	51.0	58	465	195	9.4
15	12	0.007	120	182	49.49	65.0	64	516	199	8.1
	A	0.007	150	200	38.57	49.0	34	241	188	15.9

As these data illustrate, poly(1-decene) viscosity is controlled primarily by polymerization temperature in a hydrogen-rich environment. In addition, the degree of unsaturation can be influenced by the degree to which the batch polymerization exotherm can be controlled. In instances where the temperature setpoint or exotherm exceeds 20°C over the initial temperature of 150 °C as shown by Comparative Example A compared to Examples 3 and 11 where the exotherm temperature did not exceed 20°C over the initial temperature of 150 °C , a drop in viscosity accompanied by an increase in the Iodine Number was achieved, indicating that the chain transfer by hydrogenolysis is in increasing competition with beta-hydride elimination, leading to an unsaturated chain end. Also note that catalyst decay may also become prevalent, as demonstrated in the drop-off in 1-decene conversion and procatalyst efficiency.

EXAMPLES 13-16 MAO Concentration Effects

Utilizing the conditions of Example 1 at 70°C, the ratio of MAO to Ph₂C(Cp-9-Flu)ZrCl₂ catalyst was varied from 250:1 to 1000:1 with 0.44 mmol of Al(Buⁱ)₃ being added in addition to the MAO to serve as an impurity scavenger. The polymerization conditions and properties are set forth below in Table 2.

TABLE 2

Example	catalyst (g)	MAO/ M	Temp. (°C)	Exotherm (°C)	Activity Kg/geom	% Decene Conversion	Kv (at 100°C)	Kv (at 40°C)	V _I	I, No.
13	0.007	1,018	70	72	63.69	80.2	800	9,818	289	0.4
14	0.007	1,018	70	71	59.25	74.6	982	12,250	300	0.4
15	0.007	509	70	71	58.94	74.2	1,132	14,254	307	0.5
16	0.007	254	70	70	43.05	54.2	1,308	16,881	314	0.5

As these data show, a change in MAO concentration does not effect the degree of polymer saturation as measured by Iodine Number. With a modest drop in MAO/M ratio, a slight drop in catalyst activity and decene conversion is seen, and is accompanied by a slight rise in poly(1-decene) viscosity. Although a molar ratio range of 250-1000 was used in these examples, it is only representative; this range may in fact be much more versatile than outlined in the examples, depending upon the final desired polymer viscosity and catalyst efficiency.

COMPARATIVE EXAMPLE B

The conditions of Example 2 were repeated with the same materials, however, hydrogen was not added to the reactor. Upon polymerization and workup, 39 grams of polymer was obtained, indicating a significant drop in both catalyst efficiency

and in monomer conversion. Kinematic viscosity measurements at 100 °C gave a viscosity of 1,085 cSt, demonstrating a significant increase in molecular weight. Unsaturation as measured by Iodine number was 26.35.

¹H and ¹³C NMR analysis performed on this material indicated that there was significant terminal vinylidene unsaturation in the polymer, occurring as two peaks between 110 and 140 ppm in the ¹³C NMR. Polymer sequence distribution analysis demonstrated that the product was primarily syndiotactic in structure; the dyad %rr result was 86.59%, and the pentad %rrrr was 40.36. The results of this comparative example are summarized in Table 3 and compared to similar analyses performed for Examples 1 and 2.

TABLE 3

	<u>Example or Comparative Example</u>	<u>1</u>	<u>2</u>	<u>B</u>
	H ₂ (mmol)	1,000	1,000	0
5	Polym'n Temp (°C)	70	95	95
	Activity (Kg/gcat)	65.73	64.2	5.5
	% Decene Conversion	82.8	80.9	6.9
	Kv(at100°C) (cSt)	635	144	1,085
	Iodine Number (I ₂ No.)	0.9	3.8	26.35
10	Olefins detected (via ¹³ C-NMR)	none detected	none detected	116, 139 ppm Strong
	<u>¹³C-NMR, Dyad distribution</u>			
	%rr	83.35	56.87	86.59
	%rm	16.65	43.13	13.41
15	<u>Triad distribution</u>			
	%rrr	72.95	36.10	76.81
	%rrm	20.80	41.54	19.57
	%mmm	6.25	22.35	3.62
	<u>Pentad distribution</u>			
20	%rrrrr	44.39	22.31	40.36
	%rrrrm	20.73	13.12	21.35
	%rrrrm	10.46	18.21	10.62
	%mmmmm	0.86	1.30	1.06
	%mmmmr	1.68	3.27	0.56
25	%rmmmr	3.72	17.78	2.00
	%mmrrr	9.50	9.50	5.24
	%mrrrm	7.83	0.68	15.10
	%mmrrm/rmrr	3.62	13.84	3.71

30 Examples 1 and 2 employing hydrogen addition in the polymerization of 1-decene using the catalyst Ph₂C(Cp-9-Flu)ZrCl₂ (within the scope of this invention) resulted in a substantially saturated polyolefin as compared to a polyolefin obtained without the addition of hydrogen (which is outside the scope of this invention) of Comparative Example B. Also hydrogen is able to serve all at once as a molecular

weight regulator, a catalyst activator, and as an efficient chain terminating agent for the Ph₂C(Cp-9-Flu)ZrCl₂/MAO catalyst system. Subsequent comparative examples will further demonstrate the efficiency of this type of bridged metallocene structure over other metallocenes outside the scope of this invention.

5

EXAMPLES 17- 21 Hydrogen concentration effects

Examples 17-21 were carried out to determine the magnitude of hydrogen concentration effect in the reactor. All materials used in Examples 17-21 were similar to Example 1, with 0.007 g of Ph₂C(Cp-9-Flu)ZrCl₂ catalyst dissolved in a 10 weight percent MAO in toluene solution at a 1000:1 MAO:Zr ratio. Reactor conditions were set at a temperature of 95°C with 750 ml 1-decene and 0.44 mol of Al(Buⁱ)₃ added prior to inclusion of gaseous components and catalyst solution. Each example was carried for 30 minutes, with no significant reactor exotherm. Examples 17-20 were run while feeding hydrogen on demand at the specified pressures. Example 21 differed in that hydrogen was added in a manner identical to Example 1 and combined with Nitrogen to give 200 psig total reactor pressure prior to polymerization. The results are summarized below in Table 4.

TABLE 4

Example	Pressure (psig)	H ₂ (mol)	Activity, Kg/gcat	% Decene Conversion	Kv (at	Kv (at	VI	I, No.
					100°C	40°C		
17	5	0.033	34.14	43	998	11,818	307	4.1
18	8	0.045	38.9	49	1,074	13,074	308	2.5
19	15	0.123	53.03	60	863	10,326	296	1.7
20	30	0.212	50.02	63	722	8417	288	1.4
21	200	2.18	61.13	77	512	5781	271	1.2

5 concentration of hydrogen in the polymerization vessel, partly due to the low solubility of hydrogen in the reaction medium.

EXAMPLES 22-27

Employing essentially the same procedure and materials as in Example 2,
10 polymerizations were carried out with various monomers. In Examples 22-26, 500 ml of monomer was combined with 500 ml of hexane to bring the reactor volume up to 1 liter, then Al(Bu')₃ was added to scavenge impurities. In Example 27, a mixture of monomers were used which consisted of 274 ml of 1-octene, 165 ml of 1-decene and 311 ml of 1-dodecene for a total of 750 ml in the reactor. The results of these examples are
15 summarized below in Table 5.

TABLE 5

Example	Monomer(s)	Activity Kg/cat	% Decene Conversion	Kv (at 100°C)	V1	I, No.	T _g (°C)	M _w	M _n /M _w
20	22 1-hexene	27.84	57.7	2,862	251	1.2	-42.5	13,800	2.24
	23 1-octene	40.38	79.1	888	276	0.6	-62.9	14,000	2.12
	24 1-decene	40.97	77.4	515	272	1.5	-70.5	15,500	2.04
	25 1-dodecene	39.20	72.4	402	264	1.2	-21.7	15,800	1.84
	26 1-hexadecene	38.35	68.6	193	n/a	4.2	40.1	15,700	1.82
25	27 1-octene, 1-decene, and 1-dodecene	45.9	58	561	271	1.1	-67.7	14,900	2.54

As these data show, the catalyst contemplated in the invention are versatile across a wide range of monomers and are limited only in the desired properties of the final product. Thus, polymerizing the different monomers with the specific metallocene catalyst (of Example 2) and hydrogen illustrates that even though the $K_{V_{100}}$ drops as the monomer size is increased in homopolymerization, the overall molecular weight of the resulting polymer remains approximately the same as measured by GPC. Additionally, the Iodine Number remains significantly low throughout, indicating little, if any, unsaturation present in the polymer. Also note that amorphous behavior, as measured by the glass transition temperature (T_g) reaches a minima for 1-decene as the monomer.

EXAMPLES 28-29

A dried 3 liter Büchi reactor was filled under Ar with 750 ml of dry 1-decene monomer. Next, 1.15 ml of a 25% by wt. solution of $Al(Bu^i)_3$ in hexane was added to scavenge moisture and impurities and the reactor temperature was increased to a temperature of 95°C. 1 Mole of hydrogen gas was then added to the reactor via pressure drop from a vessel of known volume. Then, a solution of 0.008 g of $Ph_2C(3-nBuCp-9-Flu)ZrCl_2$ for Example 28 and $Ph_2C(Cp-9-Flu)ZrCl_2$ for Example 29 dissolved in 8.8 ml of a 10 wt. % solution of MAO in toluene, which had been prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig Ar pressure. The reactor was maintained at a temperature of 95°C and a pressure of 200 psig for 30 minutes.

When polymerization was complete, the reactor was depressurized and

400 ml hexane was added to the polymerized decene solution to aid in transfer. Then the reactor contents were pressure transferred to a vessel equipped with an agitator containing 100 ml of acidified isopropanol and agitated for 2 minutes. A white flocculent material presumed to be an aluminum alkoxide precipitated and settled in the aqueous phase. One liter of deionized water was then added to the washed mixture, stirred, allowed to settle, and the organic layer was removed from the aluminum residue-laden aqueous layer. The polymer was obtained from the remaining organic solution by evaporation under reduced pressure in a rotary evaporator. 461 Grams of polymeric material was obtained for each example. The results are summarized below in Table 6.

TABLE 6

Example	catalyst (g)	Temp. (°C)	Activity Kg/gcat	% Decene Conversion	Kv (at 100°C)	Kv (at 40°C)	Vl	I, No.
28	0.008	92	57.66	83	335	3,379	258	2.7
29	0.007	86	61.13	77	521	5,781	271	1.2

EXAMPLES 30-31

A dried 3 liter Büchi reactor was filled under Ar with 750 ml of dry 1-

decene monomer. To this, 1.15 ml of a 25% by wt. solution of Al(Bu¹)₃ in hexane was added to scavenge moisture and impurities and the reactor temperature was increased to the desired temperature, listed in Table 7 below. Once the desired temperature was reached, 1 mole of hydrogen gas was added to the reactor via pressure drop from a vessel of known volume. Then, a solution of 0.029 g of Ph₂Si(Cp-9-Flu)ZrCl₂ dissolved in 10

wt. % solution of MAO in toluene at a 1000:1 molar MAO:Zr ratio, which had been prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig Ar pressure. The reactor was maintained at the desired temperature and at a pressure of 200 psig for 30 minutes.

When polymerization was complete, the reactor was depressurized and 400 ml hexane was added to the polymerized decene solution to aid in transfer. Then the reactor contents were pressure transferred to a vessel equipped with an agitator containing 100 ml of acidified isopropanol and agitated for 2 minutes. A white flocculent material presumed to be an aluminum alkoxide precipitated and settled in the aqueous phase. One liter of deionized water was then added to the washed mixture, stirred, allowed to settle, and the organic layer was removed from the aluminum residue-laden aqueous layer. The polymer was obtained from the remaining organic solution by evaporation under reduced pressure in a rotary evaporator. The results are summarized below in Table 7.

TABLE 7

Example	H ₂ (mol)	catalyst (g)	Temp. (°C)	Activity Kg/gcat	% Decene Conversion	Kv (at 100°C)	Kv (at 40°C)	VI	I, No.
30	1.0	0.029	40	4.45	23	1,080	12,555	314	0.8
31	1.0	0.029	95	4.95	26	110	900	222	9.2

As these data show, the nature of the bridge substituent of the catalyst (within the scope of this invention) is important both to attain an adequate rate of polymerization as well as provide some moderate effect on the efficiency of hydrogenolysis during polyermization.

COMPARATIVE EXAMPLES C-E

A dried 3 liter Büchi reactor was filled under Ar with 750 ml of dry 1-decene monomer. To this, 1.15 ml of a 25% by wt. solution of Al(Buⁱ)₃ in hexane was added to scavenge moisture and impurities and the reactor temperature was increased to the desired temperature, listed in the table below. Once at the desired temperature, hydrogen gas was added to the reactor via pressure drop from a vessel of known volume to the desired molar quantity, listed in the table below. Then, a solution of 0.022 g of Me₂C(Cp-9-Flu)ZrCl₂ dissolved in 10 wt. % solution of MAO in toluene at a 1000:1 molar MAO:Zr ratio, which had been prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig Ar pressure. The reactor was maintained at the desired temperature and at a pressure of 200 psig for 30 minutes.

When complete, the reactor was depressurized and 400 ml hexane was added to the polymerized decene solution to aid in transfer. Then the reactor contents were pressure transferred to a vessel equipped with an agitator containing 100 ml of acidified isopropanol and agitated for 2 minutes. A white flocculent material presumed to be an aluminum alkoxide precipitated and settled in the aqueous phase. One liter of deionized water was then added to the washed mixture, stirred, allowed to settle, and the organic layer was removed from the aluminum residue-laden aqueous layer. The polymer was obtained from the remaining organic solution by evaporation under reduced pressure in a rotary evaporator. The results are summarized below in Table 8.

TABLE 8

	Comparative Example	H ₂ (mol)	Temp. (°C)	Activity Kg/gcat	% Decene Conversion	K _v at 100°C)	K _v (at 40°C)	V _I	I ₂ No.
5	C	1.0	40	2.68	11	290	2,347	276	10.4
	D	1.0	95	9.66	38	18	83	237	48.5
	E	3.7	95	6.66	26	20	103	219	32.1

As these data show, employing a catalyst outside the scope of this invention effects the rate of polymerization, monomer conversion and efficiency of hydrogenolysis during polymerization thereby resulting in a significantly higher Iodine Number as compared to those 1-decene polyolefins obtained in Examples 17-21, 24, and 28-31 utilizing a catalyst within the scope of this invention.

COMPARATIVE EXAMPLES F-I

15 A dried 3 liter Büchi reactor was filled under Ar with 750 ml of dry 1-decene monomer. To this, 1.15 ml of a 25% by wt. solution of Al(Buⁱ)₃ in hexane was added to scavenge moisture and impurities and the reactor temperature was increased to the desired temperature, listed in the table below. Once at the desired temperature, hydrogen gas was added to the reactor via pressure drop from a vessel of known volume 20 to the desired molar quantity, listed in the table below. Then a solution of various unbridged metallocene catalysts (for Comparative Examples F, G, and H) and a bridged metallocene catalyst (for Comparative Example I), whose type and weight are specified in the table below, and who are known to produce amorphous polymers were dissolved in 10 wt. % solution of MAO in toluene at a 1000:1 molar MAO:Zr ratio, which had been 25 prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig

Ar pressure. The reactor was maintained at the desired temperature and at a pressure of 200 psig for 30 minutes.

When complete, the reactor was depressurized and 400 ml hexane was added to the polymerized decene solution to aid in transfer. Then the reactor contents were pressure transferred to a vessel equipped with an agitator containing 100 ml of acidified isopropanol and agitated for 2 minutes. A white flocculent material presumed to be an aluminum alkoxide precipitated and settled in the aqueous phase. One liter of deionized water was then added to the washed mixture, stirred, allowed to settle, and the organic layer was removed from the aluminum residue-laden aqueous layer.

The polymer was obtained from the remaining organic solution by evaporation under reduced pressure in a rotary evaporator. The results are summarized below in Table 9.

Table 9

Comp. Example	Procatalyst M	grams M	H ₂ (mol)	Temp. (°C)	Activity Kg/gcat	% Decene Conversion	Kv (at 100°C)	Kv (at 40°C)	V _I	I ₂ No.
F	Cp ₂ ZrCl ₂	0.030	0.0	40	5.39	29	41.4	295	196	26
G	Cp ₂ ZrCl ₂	0.013	1.0	86	15.12	34	2.56	7.81	181	157
H	(nBuCp) ₂ ZrCl ₂	0.009	1.0	89	21.97	34	2.34	7.12	163	133
I	Me ₂ Si(Cp) ₂ ZrCl ₂	0.018	1.0	40	4.28	14	12	68	175	49.1

As these data show, employing a catalyst outside the scope of this invention provides a polyolefin possessing significantly high Iodine Numbers.

COMPARATIVE EXAMPLE J

A dried 3 liter Büchi reactor was filled under Ar with 750 ml of dry 1-decene monomer. To this, 1.15 ml of a 25% by wt. solution of Al(Bu¹)₃ in hexane was added to scavenge moisture and impurities and the reactor temperature was increased to 40°C. Next, 1 mole of hydrogen gas was added to the reactor via pressure drop from a vessel of known volume. Then, a solution of 0.011g of *rac*-Et(Ind)₂ZrCl₂ dissolved in 10 wt. % solution of MAO in toluene at a 1000:1 molar MAO:Zr ratio, which had been prepared 30 minutes prior to its use, was injected into the stirring reactor under 200 psig Ar pressure. The reactor was maintained at a temperature of 40°C and at a pressure of 200 psig for 30 minutes.

After polymerization and workup, 379 grams of polymeric material was obtained with a viscosity of 702 cSt, and a viscosity index of 296. Unsaturation as measured by Iodine Number was 0.4. ¹H and ¹³C NMR analysis performed on this material indicated that there was no detectable unsaturation in the polymer by these methods. Polymer sequence distribution analysis revealed that the product was primarily isotactic in structure; i.e., the triad sequence %mm result was 78.66%.

DSC analysis performed on the polymer of Example J revealed that in addition to a glass transition temperature of -73.8°C, there was a crystalline transition temperature of 24.5°C in the polymer illustrating that the polymer is not amorphous thus making the polymer unsuitable for lubricant applications. The results of this example are summarized below in Table 10.

COMPARATIVE EXAMPLE K

Employing essentially the same procedure and materials as in

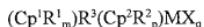
Comparative Example I, 0.024 grams of $\text{Me}_2\text{Si}(2\text{-MeInd})_2\text{ZrCl}_2$ was polymerized under the same conditions. After workup, 355 grams of poly(1-decene) was recovered, representing 64% monomer conversion. The polymer had a $K_{v,100}$ of 1,624 cSt, a VI of 341 and an Iodine Number of 0.35. DSC analysis performed on the polymer revealed that in addition to a glass transition temperature of -66.0°C, there was a crystalline transition temperature of 33.1°C in the polymer illustrating that the polymer is not amorphous thus making the polymer unsuitable for lubricant applications.

Table 10

Comp. Example	Procatalyst	H ₂ (mol)	Temp. (°C)	Activity Kg/pcat	% Decene Conversion	K _v (at 100°C)		K _v (at 40°C)	VI	I.No.	Crystalline Transition Temp. (°C)
						702	7,528				
J	<i>rac</i> -Et(Ind) ₂ ZrCl ₂	1.0	40	34.44	68				296	0.4	24.5
K	<i>rac</i> -Me ₂ Si(2-MeInd) ₂ ZrCl ₂	1.0	40	14.79	64	702	7,528	18,529	341	0.35	33.1

WHAT IS CLAIMED IS:

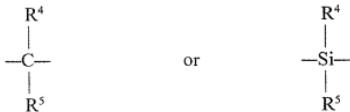
1. A process for the polymerization of α -olefin to provide a liquid
5 polyalphaolefin homo- or copolymer, the process comprising polymerizing at least one
olefin in the presence of hydrogen and a catalytically effective amount of catalyst
comprising the product obtained by combining a metallocene procatalyst with a
cocatalyst, the metallocene procatalyst being at least one compound of general formula:



10 wherein Cp^1 of ligand $(Cp^1R^1_m)$ and Cp^2 of ligand $(Cp^2R^2_p)$ are the same or different
cyclopentadienyl rings, R^1 and R^2 each is, independently, hydrogen or a hydrocarbyl,
halocarbyl, heterocarbyl, hydrocarbyl-substituted organometalloid or halocarbyl-
substituted organometalloid group containing up to about 20 carbon atoms, m is 0 to 5, p
is 0 to 5 and two R^1 and/or R^2 substituents on adjacent carbon atoms of the
15 cyclopentadienyl ring associated therewith can be joined together to form a ring
containing from 4 to about 20 carbon atoms, R^3 is a bridging group bridging Cp^1 with
 Cp^2 , M is a transition metal having a valence of from 3 to 6, each X is a non-
cyclopentadienyl ligand and is, independently, halogen or a hydrocarbyl, oxyhydrocarbyl,
halocarbyl, hydrocarbyl-substituted organometalloid, oxyhydrocarbyl-substituted
20 organometalloid or halocarbyl-substituted organometalloid group containing up to about
20 carbon atoms, and q is equal to the valence of M minus 2, the cocatalyst being an
aluminoxane and it being provided that ligand $(Cp^1R^1_m)$ is different than ligand $(Cp^2R^2_p)$
and bridging group R^3 contains at least two bulky groups.

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2. The process of Claim 1 wherein in the metallocene procatalyst,
bridging group R³ possesses the structure



10 in which groups R⁴ and R⁵ each, independently, is, or contains, a cyclic group of from 6 to about 20 carbon atoms, from 0 to 3 heteroatoms and hydrogen as the remaining atoms.

15 3. The process of Claim 2 wherein in the metallocene procatalyst, the cyclic group is a cycloalkyl, heterocycloalkyl, cycloalkenyl, heterocycloalkenyl, aryl, heteroaryl, alkaryl, alkylheteroaryl, aralkyl or heteroaralkyl group.

20 4. The process of Claim 3 wherein in the metallocene procatalyst, ligand (Cp¹R_m¹) is unsubstituted cyclopentadienyl, ligand (Cp²R_p²) is substituted or unsubstituted indenyl or fluorenyl, M¹ is zirconium, R⁴ and R⁵ each is phenyl and each ligand X is chlorine.

25 5. The process of Claim 1 wherein the metallocene procatalyst based in terms of the transition metal M, is present in an amount from 0.0001 to about 0.02 millimoles/liter and the aluminoxane cocatalyst is present in an amount from 0.01 to about 100 millimoles/liter.

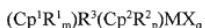
6. The process of Claim 1 wherein the α -olefin contains from 2 to
about 20 carbon atoms.

7. The process of Claim 1 wherein the α -olefin contains from about 6
5 to about 12 carbon atoms

8. The process of Claim 1 wherein the α -olefin is 1-decene.

9. The process of Claim 1 wherein the metallocene procatalyst is
10 combined with the aluminoxane cocatalyst and hydrogen in any order thereof and in the
presence or absence of α -olefin.

15 10. A liquid polyalphaolefin homo- or copolymer obtained from the
polymerization of at least one α -olefin having from 2 to about 12 carbon atoms, the
process comprising polymerizing the monomer in the presence of hydrogen and a
catalytically effective amount of a catalyst comprising the product obtained by combining
a metallocene procatalyst with a cocatalyst, the metallocene procatalyst being at least one
compound of general formula:

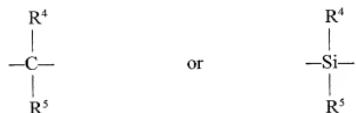


20 wherein Cp^1 of ligand $(Cp^1R^1_m)$ and Cp^2 of ligand $(Cp^2R^2_p)$ are the same or different
cyclopentadienyl rings, R^1 and R^2 each is, independently, hydrogen or a hydrocarbyl,
halocarbyl, hydrocarbyl-substituted organometalloid or halocarbyl-substituted

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organometalloid group containing up to about 20 carbon atoms, m is 0 to 5, p is 0 to 5 and
two R¹ and/or R² substituents on adjacent carbon atoms of the cyclopentadienyl ring
associated therewith can be joined together to form a ring fused to the cyclopentadienyl
ring, the fused ring containing from 4 to about 20 carbon atoms, R³ is a bridging group
5 bridging Cp¹ and Cp², M is a transition metal having a valence of from 3 to 6, each X is a
non-cyclopentadienyl ligand and is, independently, halogen or a hydrocarbyl,
oxyhydrocarbyl, halocarbyl, hydrocarbyl-substituted organometalloid, oxyhydrocarbyl-
substituted organometalloid or halocarbyl-substituted organometalloid group containing
10 up to about 20 carbon atoms, q is equal to the valence of M minus 2, the cocatalyst being
an aluminoxane and it being provided that ligand (Cp¹R¹_m) is different from ligand
(Cp²R²_p) and bridging group R³ contains at least two bulky groups.

11. The polyalphaolefin of Claim 10 wherein bridging group R³
possesses the structure



in which groups R⁴ and R⁵ each, independently, is, or contains, a cyclic group of from 6 to
about 20 carbon atoms, from 0 to 3 heteroatoms and hydrogen as the remaining atoms.

12. The polyalphaolefin of Claim 11 wherein in the metallocene procatalyst, the cyclic group is a cycloalkyl, heterocycloalkyl, cycloalkenyl, heterocycloalkenyl, aryl, heteroaryl, alkaryl, alkylheteroaryl, aralkyl or heteroaralkyl group.

5

13. The polyalphaolefin of Claim 12 wherein in the metallocene procatalyst, ligand ($Cp^1R_m^1$) is unsubstituted cyclopentadienyl, ligand ($Cp^2R_p^2$) is substituted or unsubstituted indenyl or fluorenyl, M^1 is zirconium, R^4 and R^5 each is phenyl and each ligand X is chlorine.

10

14. The polyalphaolefin of Claim 10 wherein the metallocene procatalyst is combined with hydrogen and the cocatalyst in any order thereof in the presence or absence of monomer.

15

15. The polyalphaolefin of Claim 11 wherein the metallocene procatalyst is combined with hydrogen and the cocatalyst in any order thereof in the presence or absence of monomer.

20

16. The polyalphaolefin of Claim 12 wherein the metallocene procatalyst is combined with hydrogen and the cocatalyst in any order thereof in the presence or absence of monomer.

17. The polyalphaolefin of Claim 13 wherein the metallocene procatalyst is combined with hydrogen and the cocatalyst in any order thereof in the presence or absence of monomer.

5 18. The polyalphaolefin of Claim 10 wherein the monomer is 1-decene.

10 19. The polyalphaolefin of Claim 10 wherein polymerization is carried out under solution polymerization conditions.

15 20. The polyalphaolefin of Claim 10 wherein polymerization is carried out under slurry polymerization conditions.

20 21. The polyalphaolefin of Claim 10 possessing a M_w of from about 500 to about 80,000, a M_w/M_n of from about 1.0 to about 10, a Kv_{100} of from about 10 to about 10,000, an Iodine Number of from about 0.0 to about 10 and a T_g of below about -20°C and wherein the polyalphaolefin is substantially amorphous.

25 22. The polyalphaolefin of Claim 21 possessing a M_w of from about 750 to about 60,000, a M_w/M_n of from about 1.5 to about 5, a Kv_{100} of from about 20 to about 7,500, an Iodine Number of from about 0.1 to about 5 and a T_g of below about -30°C and wherein the polyalphaolefin is substantially amorphous.

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23. The polyalphaolefin of Claim 22 possessing a M_w of from about 1,000 to about 40,000, a M_w/M_n of from about 1.75 to about 4, a Kv_{100} of from about 25 to about 5,000, an Iodine Number of from about 0.2 to about 3 and a T_g of below about -40°C and wherein the polyalphaolefin is substantially amorphous.

5

24. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 10.

25. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 13.

27. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 18.

29. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 20.

30. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 21.

20

31. A lubricating oil composition comprising a lubricating oil and a viscosity-modifying amount of the liquid polyalphaolefin of Claim 22.

32. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 10.

5 33. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 13.

10 34. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 18.

15 35. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 20.

36. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 21.

37. A method for improving the viscosity index of a lubricating oil composition comprising adding to the composition a viscosity-modifying amount of the liquid polyalphaolefin of Claim 22.

ABSTRACT OF THE DISCLOSURE

A liquid polyalphaolefin homo- or copolymer, preferably 1-decene, which is substantially amorphous is obtained by a polymerization process employing hydrogen and a particular type of metallocene catalyst. Additionally, liquid polyalphaolefin homo-
5 or copolymer containing from 2 to about 12 carbon atoms possess a unique combination of properties, i.e., low molecular weight (M_w), low polydispersity index (M_w/M_n), controllable kinematic viscosity (Kv_{100}), low Iodine Number (I_2) and low glass transition temperature (T_g) and are substantially amorphous. The liquid polyalphaolefin homo- or copolymers provided herein are useful for manufacturing a variety of products including lubricating oils in which the polyalphaolefin functions as a viscosity modifier.

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COMBINED DECLARATION FOR PATENT
APPLICATION AND POWER OF ATTORNEY

Atty Docket No. D-6384
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(Includes Reference to PCT International
Applications)

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name.

I believe I am an original, first and joint inventor of the invention entitled:

"PROCESS FOR PRODUCING LIQUID POLYALPHOLEFIN POLYMER,
METALLOCENE CATALYST THEREFOR, THE RESULTING
POLYMER AND LUBRICANT CONTAINING SAME",

which is described and claimed in the patent specification which

- is attached hereto,
 was filed on and accorded serial number ,

and for which invention Letters Patent are sought.

I hereby state that I have reviewed and understand the contents of the above identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, Sec. 1.56(a).

I hereby claim foreign priority benefits under Title 35, United States Code, Sec. 119 of any foreign application(s) for patent or inventor's certificate listed below and have also identified below any foreign application for patent or inventor's certificate having a filing date before that of the application on which priority is claimed:

PRIOR FOREIGN/PCT APPLICATIONS AND PRIORITY CLAIMS UNDER 35 U.S.C. 119			
COUNTRY (if PCT, indicate "PCT")	APPLICATION NO.	DATE OF FILING (month,day,year)	PRIORITY CLAIMED

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COMBINED DECLARATION FOR PATENT
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Page 2

I hereby claim the benefit under Title 35, United States Code, Sec.120 of any United States application(s) listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in the prior United States application in the manner provided by the first paragraph of Title 35, United States Code, Sec.112, I acknowledge the duty to disclose material information as defined in Title 37, Code Federal Regulation Sec.1.56(a) which occurred between the filing date of the prior application and the national or PCT international filing date of this application:

PRIOR U.S. APPLICATIONS OR PCT INTERNATIONAL APPLICATIONS DESIGNATING THE U.S. FOR BENEFIT UNDER 35 U.S.C. 120				
U.S. APPLICATIONS		STATUS (CHECK ONE)		
US APPLN. NO.	US FILING DATE	PATENTED	PENDING	ABANDONED
PCT APPLICATIONS DESIGNATING THE U.S.				
PCT APPLICATION NO.	PCT FILING DATE	US SERIAL NOS. ASSIGNED (if any)		

I hereby appoint the following attorney's and/or agent(s) to prosecute this application and to transact all business in the Patent and Trademark Office connected therewith: Raymond D. Thompson - Reg. No. 30,695; Daniel Reitenbach - Reg. No. 30,970,

Address all correspondence to: Raymond D. Thompson Uniroyal Chemical Company, Inc. World Headquarters Middlebury, CT 06749	Direct telephone calls to: Raymond D. Thompson tel. no.: (203) 573-4385.
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I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under Section 1001 of Title 18 of the United States Code and that such willful false statements may jeopardize the validity of the application or any patent issued thereon.

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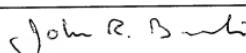
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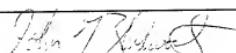
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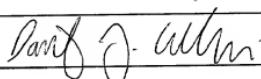
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Page 4

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